

D412-664-243	CROSSTUBE ASSEMBLY (412 HI AFT)	DART AEROSPACE LTD	ENGINEERING ORDER	D412-664-243-E-4	SHEET 1 OF 3	SCALE: NTS
DRAWN	CP	CHECKED		MFG. APPR.	DE APPR.	
DATE	12.08.21	DATE		APPROVED	DATE	

**PURPOSE:**  
REMOVED ABRASION STRIP IN FAVOR OF A THIN LAYER OF PROSEAL 890. THIS ENGINEERING ORDER SUPERCEDES DEO D412-664-243-E-1

**CHANGE:**

**PARTS LIST IS AMENDED AS FOLLOWS:**

**IS:**

Item	Qty	Part Number	Description
	-243		
6	0	D2856-600-1009	ABRASION STRIP

**WAS:**

6	2	D2856-600-1009	ABRASION STRIP
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**NOTES 2 AND 14, SHEET 1 ARE AMENDED AS FOLLOWS:**

**IS:**

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA)  
PAINT OUTSIDE PER DART QSI 005 4.2  
AFTER PAINTING, APPLY CLEAR COAT ON HATCHED AREA

- 14) APPLY A THIN COAT OF PROSEAL 890 ON INSIDE CONCAVE SURFACE OF D3189-1 CHAFING SHIELD AND LET CURE PER MANUFACTURER'S INSTRUCTIONS. INSTALL PROSEAL D3189-1 CHAFING SHIELD ONTO CROSSTUBE BY APPLYING A THIN COAT OF PROSEAL 890 ONTO CROSSTUBE. BE SURE TO ELIMINATE ANY AIR GAPS.

**WAS:**

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 14) INSTALL D2856-600-1009 ABRASION STRIPS WITH A 0.13 REF GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.

**PRELIMINARY ISSUE**

CP 12/13/23

DRAWING NO.	TITLE	REV. E	DART AEROSPACE LTD	D.E.O. NO.	SHEET NO.	SCALE
D412-664-243	CROSSTUBE ASSEMBLY (412 HI AFT)		ENGINEERING ORDER	D412-664-243-E-4	SHEET 2 OF 3	NTS
DRAWN	CHECKED	DATE	MFG. APPR.	APPROVED	DE APPR.	
DATE	12.08.21	DATE	12.08.21	DATE	DATE	

IS:

D3189-1 CHAFING SHIELD (1, INSTALLED OVER PROSEAL 890)  
MS21920-28 CLAMP, 2X  
2 PL

WAS:

14 16

D2856-600-1009 ABRASION STRIP  
D3189-1 CHAFING SHIELD (1, INSTALLED OVER ABRASION STRIP)  
MS21920-28 CLAMP, 2X  
2 PL

16 14

11.83  
TO CLAMP  
11.60  
TO  
CHAFING  
SHIELD

D412-664-603  
BENT TUBE

D3189-1  
REF

4.00  
CLAMP SPACING  
4.38  
CHAFING SHIELD, REF

2.00  
1.00

D412-664-243  
ASSEMBLY DETAIL

PRELIMINARY ISSUE

12/10/23

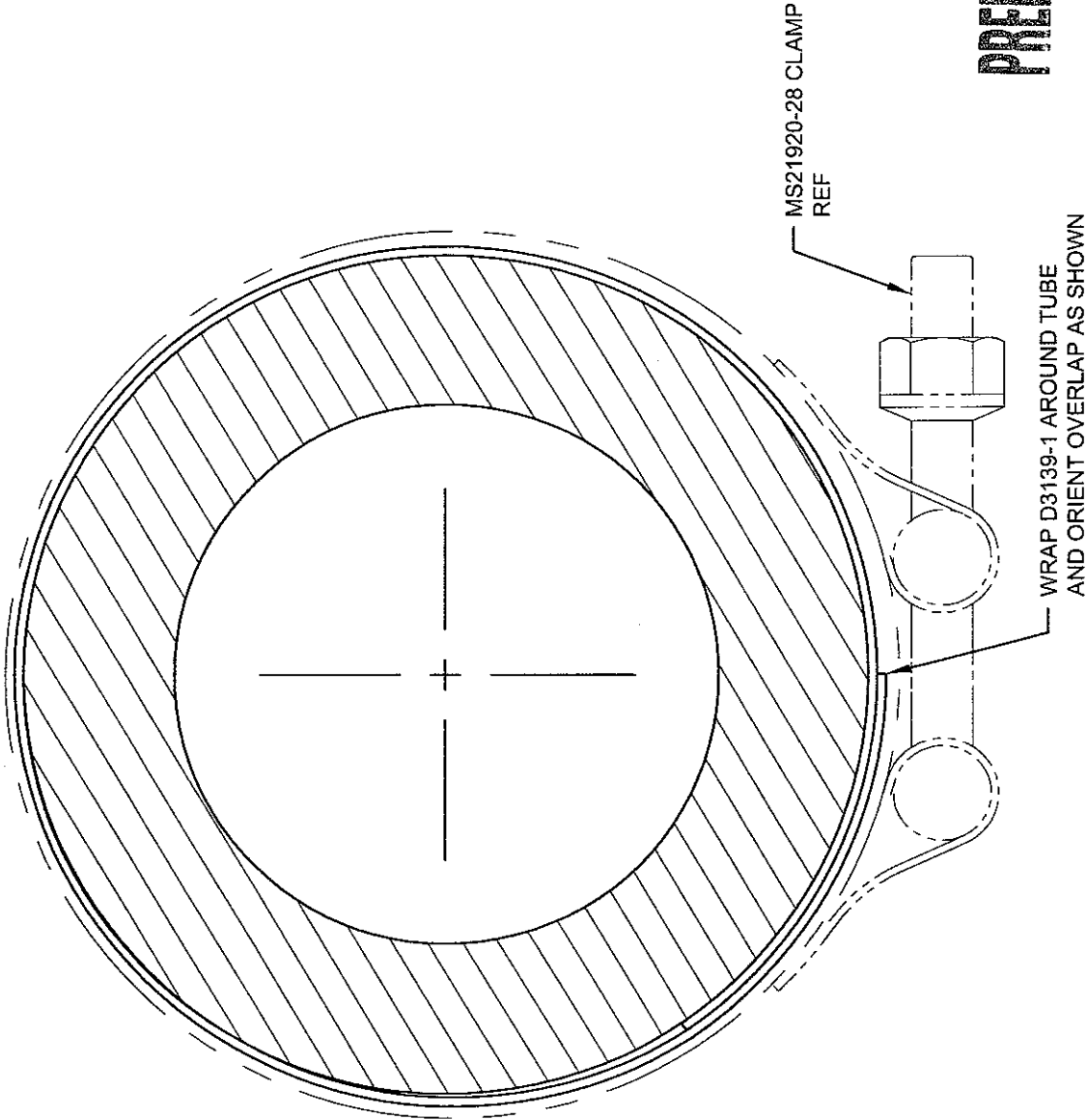
2

MASK AREA PRIOR TO PAINTING AND  
APPLY CLEAR COAT AFTER PAINTING

2.00

C  
SYM

DRAWING NO. D412-664-243	TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	REV. E	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D412-664-243-E-4	SHEET NO. SHEET 3 OF 3	SCALE NTS
DRAWN [Signature]	CHECKED [Signature]	DATE 12.08.21	MFG. APPR.	APPROVED	DE APPR.		
DATE 12.08.21	DATE 12.08.22	DATE	DATE	DATE	DATE		



**PRELIMINARY ISSUE**

*Q12/13/23*

**SECTION A-A**  
CHAFING SHIELD DETAIL  
VIEW ROTATED, NOT TO SCALE